

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003286**Date Inspected:** 03-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

The Quality Assurance Inspector was informed that the electrical power remained to the fabrication bays and the Quality Assurance Office. The Quality Assurance Inspector walked through all the fabrication bays. In Bay 4, two ZPMC employees were laying out lines with a chalk line in preparation for heat straightening on a diaphragm plate. In the rest of the bays no work was observed.

The Quality Assurance Inspector performed Ultrasonic verification to the partial joint penetration weld number 7 on DP-059-001. On March 8th 2008 ZPMC performed their Ultrasonic Testing and recorded an indication at the 480mm Y axis with a depth of penetration 8.33 mm and the thickness of the rib at 11.9 mm. On the member, ZPMC recorded an indication at the 515 mm y axis, the thickness at 12.3 mm and the screen height percentage at 12.3 mm. The Quality Assurance Inspector found the indication to be at the 495 mm y axis, the thickness to be 12.2 mm and the depth of penetration to be 9 mm. ABF Representative was informed of the discrepancy.

**Summary of Conversations:**

As stated in the contents of the above report.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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## WELDING INSPECTION REPORT

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remedial efforts please contact Ady Velasco(707) 552 7715, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bertlesman,Greg	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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